WHAT IS CLAIMED IS:

1. An image forming apparatus, comprising:

a belt member, seamed to form an endless belt which is stretched by a plurality of roller members and circulated in a first direction, the belt member provided with an electrode portion at a first end portion thereof in a second direction perpendicular to the first direction; and

a cleaning member, abutted against the belt member,

wherein a seam of the belt member extends obliquely relative to the first direction such that an end of the seam confronting the electrode portion is situated in an upstream side of the first direction.

2. The image forming apparatus as set forth in claim 1, wherein:

the belt member comprises a substrate, a conductive layer laminated on the substrate, and a semiconductive layer laminated on the conductive layer so as to have a smaller dimension than the conductive layer in the second direction; and

the electrode portion is formed on both of the conductive layer and the semiconductive layer.

3. The image forming apparatus as set forth in claim 1, further comprising an electrode roller abutted against the electrode portion to apply a bias voltage for primarily transferring a toner image on the belt member.

4. The imag forming apparatus as set forth in claim 3, further comprising a sensor, which monitors the bias voltage to detect a breakage of the seam.

5. An image forming apparatus, comprising:

a belt member, seamed to form an endless belt which is stretched by a plurality of roller members and circulated in a first direction, the belt member provided with an electrode portion at a first end portion thereof in a second direction perpendicular to the first direction; and

a cleaning member, abutted against the belt member,

wherein a seam of the belt member extends obliquely relative to the first direction such that an end of the seam confronting the electrode portion is situated in a downstream side of the first direction.

6. The image forming apparatus as set forth in claim 5, wherein:

the belt member comprises a substrate, a conductive layer laminated on the substrate, and a semiconductive layer laminated on the conductive layer so as to have a smaller dimension than the conductive layer in the second direction; and

the electrode portion is formed on both of the conductive layer and the semiconductive layer.

7. The image forming apparatus as set forth in claim 5, further comprising an electrode roller abutted against the electrode portion to apply a bias voltage for primarily transferring a toner image on the belt member.

8. An image forming apparatus, comprising:

a belt member, seamed to form an endless belt which is stretched and circulated by a plurality of roller members, the belt member provided with an indicator which indicates a reference position of the circulation of the belt member; and

a controller, which stops the circulation of the belt member such that the indicator is situated at a position between adjacent ones of the rollers.

9. The image forming apparatus as set forth in claim 8, wherein the adjacent rollers are ones arranged with a largest interval.

10. An image forming apparatus, comprising:

a belt member, seamed to form an endless belt which is stretched and circulated by a plurality of roller members, the belt member provided with a first region corresponding to an image forming region, and a second region provided with a seam of the belt member and corresponding to a non-image forming region;

a cleaning member, which is abutted against the belt member; and

a mechanism, which first bring the cleaning member into contact with a first widthwise end portion in the second region of the belt member, so that the cleaning member is entirely brought into contact with the belt member at a second widthwise end portion in the second region thereof,

wherein a track of a contact point between the cleaning member and the belt member extends so as to avoid the seam.

11. The image forming apparatus as set forth in claim 10, wherein the belt member is provided with an electrode portion at the first widthwise end thereof, through which a bias voltage for primarily transferring a toner image is applied.

12. The image forming apparatus as set forth in claim 10, wherein the mechanism first separate the cleaning member from the second widthwise end portion of the belt member, so that the cleaning member is entirely separated from the belt member at the first widthwise end portion thereof.

13. An image forming apparatus, comprising:

a belt member, seamed to form an endless belt which is stretched and circulated by a plurality of roller members, the belt member provided with a first region corresponding to an image forming region, and a second region provided with a seam of the belt member and corresponding to a non-image forming region;

a cleaning member, which is abutted against the belt member; and

a mechanism, which first bring the cleaning member into contact with a first widthwise end portion in the second region of the belt member, so that the cleaning member is entirely brought into contact with the belt member at a second widthwise end portion in the second region thereof,

wherein a track of a contact point between the cleaning member and the belt member extends so as to cross the seam.

14. The image forming apparatus as set forth in claim 13, wherein the belt member is provided with an electrode portion at the first widthwise end thereof, through which a bias voltage for primarily transferring a toner image is applied.

15. The image forming apparatus as set forth in claim 13, wherein the mechanism first separate the cleaning member from the second widthwise end portion of the belt member, so that the cleaning member is entirely separated from the belt member at the first widthwise end portion thereof.

16. An image forming apparatus, comprising:

a belt member, seamed to form an endless belt which is stretched and circulated by a plurality of roller members, the belt member provided with a first region onto which a toner image is primarily transferred, and a second region provided with a seam of the belt member and onto which the toner image is not transferred;

a secondary transfer member, which is abutted against the belt member to secondarily transfer the toner image from the belt member to a recording medium; and

a mechanism, which first bring the secondary transfer member into contact with a first widthwise end portion in the second region of the belt member, so that the secondary transfer member is entirely brought into contact with the belt member at a second widthwise end portion in the second region thereof,

wherein a track of a contact point between the secondary transfer member and the belt member extends so as to avoid the seam.

17. The image forming apparatus as set forth in claim 16, wherein the belt member is provided with an electrode portion at the first widthwise nd thereof, through which a bias voltage for primarily transferring the toner image is applied.

18. The image forming apparatus as set forth in claim 16, wherein the mechanism first separate the secondary transfer member from the second widthwise end portion of the belt member, so that the secondary transfer member is entirely separated from the belt member at the first widthwise end portion thereof.

19. An image forming apparatus, comprising:

a belt member, seamed to form an endless belt which is stretched and circulated by a plurality of roller members, the belt member provided with a first region onto which a toner image is primarily transferred, and a second region provided with a seam of the belt member and onto which the toner image is not transferred;

a secondary transfer member, which is abutted against the belt member to secondarily transfer the toner image from the belt member to a recording medium; and

a mechanism, which first bring the secondary transfer member into contact with a first widthwise end portion in the second region of the belt member, so that the secondary transfer member is entirely brought into contact with the belt member at a second widthwise end portion in the second region

thereof,

wherein a track of a contact point between the secondary transfer member and the belt member extends so as to cross the seam.

20. The image forming apparatus as set forth in claim 19, wherein the belt member is provided with an electrode portion at the first widthwise end thereof, through which a bias voltage for primarily transferring the toner image is applied.

21. The image forming apparatus as set forth in claim 19, wherein the mechanism first separate the cleaning member from the second widthwise end portion of the belt member, so that the cleaning member is entirely separated from the belt member at the first widthwise end portion thereof.